

1   **WHAT IS CLAIMED IS:**

- 1           1.     A disk drive, comprising:  
2           an enclosure defining an exterior surface, the enclosure including:  
3                 a base;  
4                 a cover; and  
5                 a hinge mechanically coupling the base to the cover such that the hinge forms a  
6                 portion of the exterior surface of the enclosure;  
7           a spindle motor attached to the base;  
8           a disk mounted to the spindle motor, and  
9           a head stack assembly pivotally coupled to the base.
- 1           2.     The disk drive of Claim 1, wherein the base, the cover and the hinge of the  
2           enclosure are unitarily molded to form a single-piece enclosure.
- 1           3.     The disk drive of Claim 1, wherein the base, the cover and the hinge of the  
2           enclosure are injection molded together.
- 1           4.     The disk drive of Claim 1, wherein the enclosure includes a plastic material.
- 1           5.     The disk drive of Claim 1, wherein the enclosure is formed of a plastic material.
- 1           6.     The disk drive of Claim 4, wherein the plastic material includes a non-plastic  
2           filler.
- 1           7.     The disk drive of Claim 6, wherein the non-plastic filler includes a conductive  
2           material.
- 1           8.     The disk drive of Claim 4, wherein the plastic material includes a filler having an  
2           electro-magnetic shielding characteristic.
- 1           9.     The disk drive of Claim 1, wherein at least a portion of the base includes a metal.

1           10.    The disk drive of Claim 1, wherein at least one of the base and the cover includes  
2 a non-plastic material and wherein the hinge is insert molded onto the base and the cover.

1           11.    The disk drive of Claim 10, wherein the non-plastic material includes a metal.

1           12.    The disk drive of Claim 1, wherein the base is formed of a metal and wherein the  
2 cover and the hinge are unitarily formed and wherein the unitarily formed cover and hinge is  
3 insert molded onto the base.

1           13.    The disk drive of Claim 1, wherein the hinge is formed in a configuration wherein  
2 the cover is initially oriented at about 45 degrees relative to the base.

1           14.    The disk drive of Claim 1, wherein the hinge is formed of a same material as the  
2 cover and the base.

1           15.    The disk drive of Claim 1, wherein the hinge includes a hinge bead, the hinge  
2 bead being external to an internal space of the disk drive formed when the enclosure is closed

1           16.    The disk drive of Claim 1, wherein the cover forms a lip over the base when the  
2 enclosure is closed.

1        17.    A method of manufacturing a disk drive, comprising:  
2                a single molding step to form an enclosure including a base, a cover and a hinge  
3        mechanically coupling the base to the cover such that the hinge forms a portion of an  
4        exterior surface of the enclosure;  
5                attaching a spindle motor to the base;  
6                mounting a disk to the spindle motor, and  
7                pivotally coupling a head stack assembly pivotally to the base.

1        18.    The method of Claim 17, wherein the molding step is an injection-molding step.

- 1        19.    A method of manufacturing a disk drive, comprising:  
2            providing a base;  
3            providing a cover;  
4            molding a hinge onto the base and the cover to mechanically couple the base to  
5    the cover such that the hinge forms a portion of an exterior surface of the enclosure;  
6            attaching a spindle motor to the base;  
7            mounting a disk to the spindle motor, and  
8            pivotally coupling a head stack assembly pivotally to the base.
- 1        20.    The method of Claim 19, wherein the molding step is an insert-molding step.